

ASAP 02/09-03/09 Patel

Work Order ID 51693

August 27, 2009 1:17:54 PM

Item ID: D3928-1

Accept

Revision ID: A

Item Name: Bracket

Start Date: 8/28/09 Start Qty: 8.00

Required Date: 8/31/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3928

Rev A

12

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3928

Dwg Rev: A

Prog Rev: A

grain along 4.97"

2-Deburr if necessary

IB 9-9-1

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

IB 9-9-1

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ASAP



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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Memo

0.00



Brake NC

0.00

Brake NC

1-Bend as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 801/02/01

(12)

f

88 09/07/02

12

⇒ 801/02/02

(12)

f

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 09-09-2 (12)

160

White Gloss(Ref:4.3.5.1) per QS1005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time: 8:40am
Oven Temperature: 320°F
Finish Time: 8:10am

341 09-09-02

12

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-09-2

(12)

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Setup Start



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Stop



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Cust Item ID:

Required Date: 8/31/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location:

135A

0.00



Packaging

Memo

0.00

Packaging

these give 2 to Sian

Qty 2 taken by Sian. 09.09.03 822

04/4/4 (10)+2

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/08

mf
09-09-04

Picklist Print

August 27, 2009 1:17:53 PM

Page 1

Work Order ID: 51693

Parent Item: D3928-1RevA

Parent Item Name: Bracket

Comments:

Start Date: 8/28/09

Required Date: 8/31/09

Start Qty: 8.00

Required Qty: 8.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M6061T6S.050 | | Purchased | No | | | 100 | sf | 53.4999 | 0.6189 | 9283 | | |



6061-T6 .050 Sheet



B9-9-1

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 53.4998 | |
| 110791 | 51.4998 | |
| 17349 | 2 | |

110791

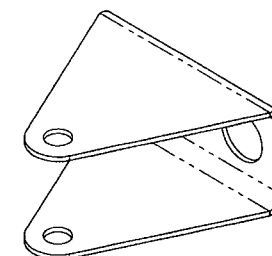
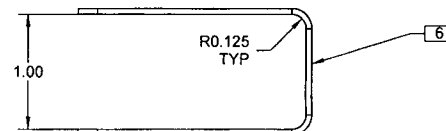
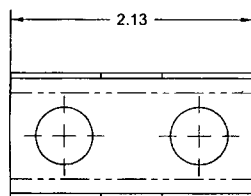
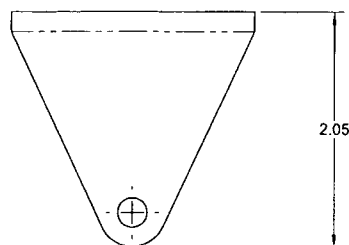
8 7 6 5 4 3 2 1

D

C

B

A



Handwritten: 51693

D3928-1 BRACKET
MADE FROM D3928-1F

RELEASED
Handwritten: 09/04/17

NOTES:

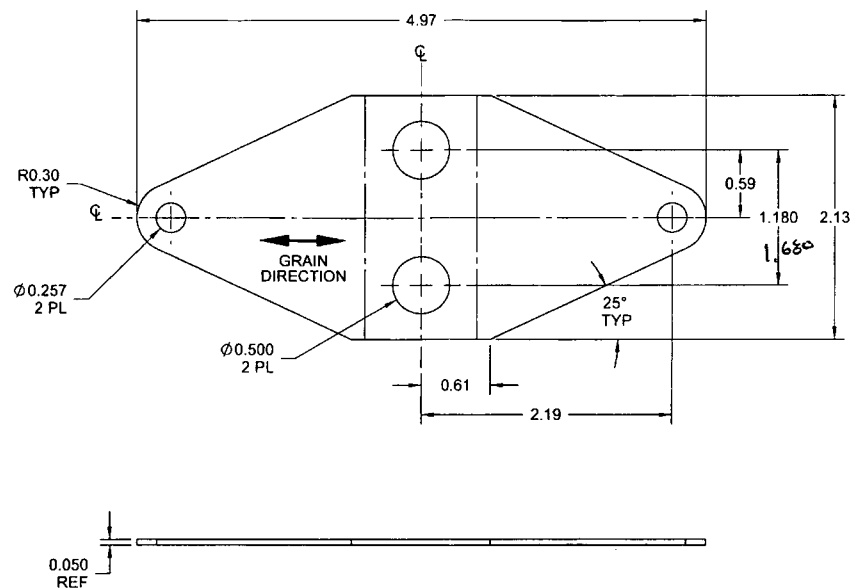
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3928-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

| REV. | NEW ISSUE | DESCRIPTION | BY | DATE |
|------------|-----------|-------------|----|------|
| DESIGN | | | | |
| DRAWN | | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 09.04.01 | | | |

| | |
|---|------------------------|
| DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| DRAWING NO. D3928 | REV. A SHEET 1 OF 2 |
| TITLE BRACKET | |
| SCALE NTS | |

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8 7 6 5 4 3 2 1



D3928-1F BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

| | | | |
|------------|----------|---|--------------|
| DESIGN | | DART AEROSPACE USA, INC. | |
| DRAWN | | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3928 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BRACKET | NTS |
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